

Date: Wednesday, 10/11/2006 11:11:44 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : NUT PLATE ASSEMBLY
Job Number : 28918	
Estimate Number : 11051	
P.O. Number : N/A	Part Number : D2872043
This Issue : 10/11/2006 S.O. No. : N/A	Drawing Number : D2872 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <u> </u>	Due Date : 10/30/2006 Qty: 30 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est A 05/09/13 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0375X00750	6061T6 BAR
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Comment: Qty.: 0.3281 f(s)/Unit Total : 9.8438 f(s)
 Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8)
 (M6061T6B0.375x00.750) Batch: M18237
 Identify for D2872-3

J.F. 06/10/23

30

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 0.750" x 0.375" x 3.750" long

J.F. 06/10/23

30

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA550 and Dwg D2872
 Identify as D2872-3 Dwg Rev A Folio Rev AA

ml 06/10/24

30

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/10/24

30

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 06/10/25 x30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 11:11:44 AM
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Part Number: D2872043

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2- C'sink as per Dwg D2872

ml 06/10/27

(30)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/10/31

(30)

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

am 06/11/01

counted

yl

06/11/01

X30

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION

FF 06-11-03

30

10.0 MS20426AD45 Rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total : 180.0000 Each(s)

Rivet

Pick;

Qty

Part Number

Description

Batch

6

MS20426AD4-5

Rivet

M4067

FF 06-11-03

30

11.0 MS21086L5 Nut Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 90.0000 Each(s)

Nut Plate

Pick;

Qty

Part Number

Description

Batch

3

MS21086L5

Nut Plate

M10540 x 87 / M102380 x 3

FF 06-11-03

30

12.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2872

2-Identify as D2872-043

FF 06-11-09

30

Riv = .104

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 06/11/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 11:11:44 AM
User: Kim Johnston

Process Sheet

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Drawing Name: NUT PLATE ASSEMBLY

Job Number: 28918

Part Number: D2872043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12/06/11/09 30

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST392

12/06/11/10 30

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/06/11/10 30

Job Completion



12/06/11/10

Dart Aerospace Ltd

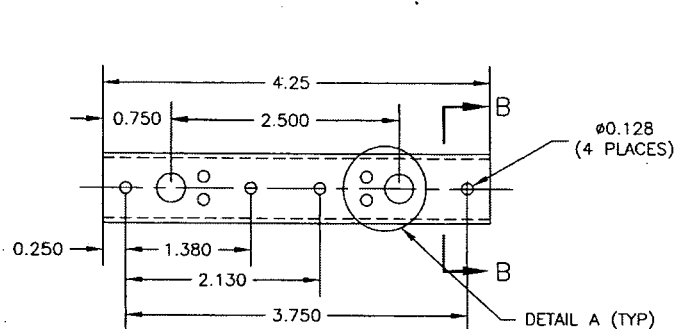
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

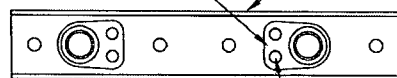
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



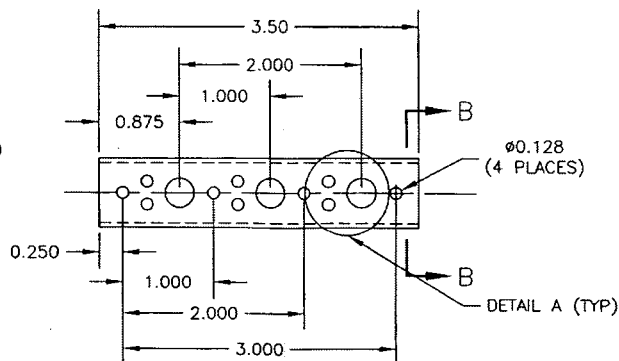
D2872-1

MS21086L5 NUT PLATE
(TYP 2 PLACES)



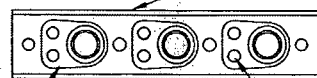
D2872-041

MS20426AD4-5
RIVET (TYP 4 PLACES)



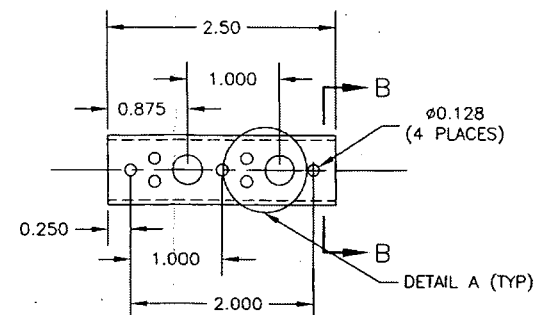
D2872-3

D2872-3



D2872-043

MS20426AD4-5
RIVET (TYP 6 PLACES)



D2872-5

MS21086L5 NUT PLATE
(TYP 2 PLACES)



D2872-045

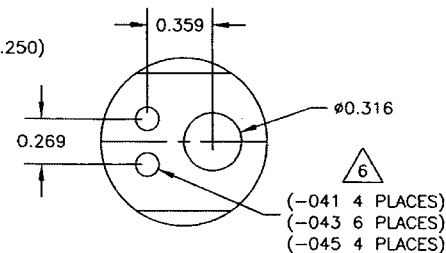
MS20426AD4-5
RIVET (TYP 4 PLACES)

D2872-1/-3/-5 RADIUS BLOCK

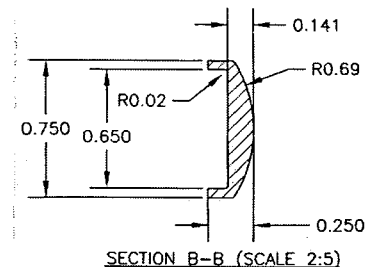
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B0.750X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B0.750X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.050 DEEP + C'SINK CURVED SIDE Ø0.225 x 100°

D2872-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21086L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-5 RIVETS



DETAIL A (SCALE 2:5)



SECTION B-B (SCALE 2:5)

D2872-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2872-041	NUT PLATE ASSEMBLY
	X		D2872-043	NUT PLATE ASSEMBLY
		X	D2872-045	NUT PLATE ASSEMBLY
1			D2872-1	RADIUS BLOCK
	1		D2872-3	RADIUS BLOCK
		1	D2872-5	RADIUS BLOCK
4	6	4	MS20426AD4-5	RIVET
2	3	2	MS21086L5	NUT PLATE

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A	05.07.26	NEW ISSUE
DESIGN	PH	DART DART AEROSPACE LTD BARRISBURGH, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. D2872
DATE	05.07.26	TITLE RADIUS BLOCK
		REV. A SHEET 1 OF 1 SCALE 4:5

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28318

RELEASED
05.07.26

DART AEROSPACE LTD		Work Order: 28918
Description: RADIUS BLOCK		Part Number: D2872-3
Inspection Dwg: D2872, Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

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Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	± 0.30	3.501	—			
2.000	± 0.05	2.000	—			
0.875	± 0.05	0.875	—			
0.250	± 0.05	0.250	—			
1.000	± 0.05	0.999	—			
2.000	± 0.05	2.000	—			
3.000	± 0.05	3.000	—			
Ø 0.128	± 0.05	Ø 0.129	—			
Ø 0.316	± 0.06	Ø 0.317	—			
0.269	± 0.05	0.269	—			
0.750	± 0.10	0.753	—			
0.650	± 0.10	0.645	—			
0.250	± 0.10	0.250	—			
0.141	± 0.10	0.141	—			
R 0.02	± 0.030	R 0.026	—			
Ø 0.230 X 0.050	± 0.010	Ø 0.227 X 0.049	—			

Measured by: <i>Jul</i>
Date: 06/10/24

Audited by: <i>En</i>
Date: 06/10/24

QC Prototype Approval: <i>[Signature]</i>
Date: 06-10-25

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	